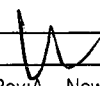
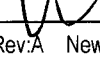


Date: Tuesday, 10/06/2008 12:36:32 PM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	MOUNTING BRACKET
<b>Job Number</b> :	39777		
<b>Estimate Number</b> :	12473		
<b>P.O. Number</b> :		<b>Part Number</b> :	D3246041
<b>This Issue</b> :	10/06/2008	<b>Drawing Number</b> :	D3246 REV A1
<b>Prsht Rev.</b> :	NC	<b>Project Number</b> :	N/A
<b>First Issue</b> :	//	<b>Drawing Revision</b> :	A1
<b>Previous Run</b> :	37268	<b>Material</b> :	
<b>Written By</b> :		<b>Due Date</b> :	17/06/2008
<b>Checked &amp; Approved By</b> :		<b>Qty:</b>	10 Um: Each
<b>Comment</b> :	Est Rev:A New Issue 06-06-22 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M2024T3S050	2024-T3 .050 sheet
-----	-------------	--------------------



4.2



**Comment:** Qty.: 0.3252 sf(s)/Unit Total : 3.2519 sf(s)  
 2024-T3 .050 sheet  
 Material: 2024-T3 (QQ-A-250/4) 0.050" thick  
 (M2024T3S.050)  
 Identify for D3246-1 Batch: 105646 B 8-6-10

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



**Comment:** FLOW WATER JET  
 1-Cut as per Dwg Dsi9279  
 Dwg Rev: A1  
 Prog Rev: A1

B 8-6-10

2-Deburr if necessary

B 8-6-10

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



B 8-6-10

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------

**Comment:** SECOND CHECK

5.0	BRAKE NC	NC BRAKE
-----	----------	----------












**Comment:** NC BRAKE  
 Deburr  
 Form as per Dwg D3246  
 C'sink as per Dwg D3246

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: D3246-041 PAR #: N/A Fault Category: Prod / Prod. Ass NCR: (Yes) No DQA: D Date: 28/06/20  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: 39771		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
8/6/10	2.0	one part scrap due to having a notch/groove cut approx. in center outside edge		Scrap and Destroy no Rephe N QTY 1	 8-6-10	 08/06/10	 08/06/10	 08/06/10
		RL water jet still had pressure in the line as it moved across the part to the next starting position				 08/06/10	 08/06/10	 08/06/10

NOTE: Date & initial all entries

Date: Tuesday, 10/06/2008 12:36:32 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING BRACKET

Job Number: 39777

Part Number: D3246041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/06/13 (10)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FL 08/06/13 (11)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-H 08/06/13 (11X)

9.0

MS20426AD33

Rivet



Comment: Qty.: 8.0000 Each(s)/Unit Total: 80.0000 Each(s)

Rivet

Pick:

Qty Part Number Description Batch

8 MS20426AD3-3 Rivet

M19099

EB 08/06/16

10.0

MS21059L3

Nut Plate



Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)

Nut Plate

Pick:

Qty Part Number Description Batch

4 MS21059L3 Nut Plate

M106042

EB 08/06/16

Identify as D3246-041

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install Nut Plates as per Dwg D3246

EB 08/06/16 (11X)

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/06/16 (10)

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/06/2008 12:36:32 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING BRACKET

Job Number: 39777

Part Number: D3246041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5777

*Rec'd 8/16*

*(11)*

14.0

QC21

FINAL INSPECTION/W/O RELEASE



*08/06/19*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*MF 08-06-17*

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

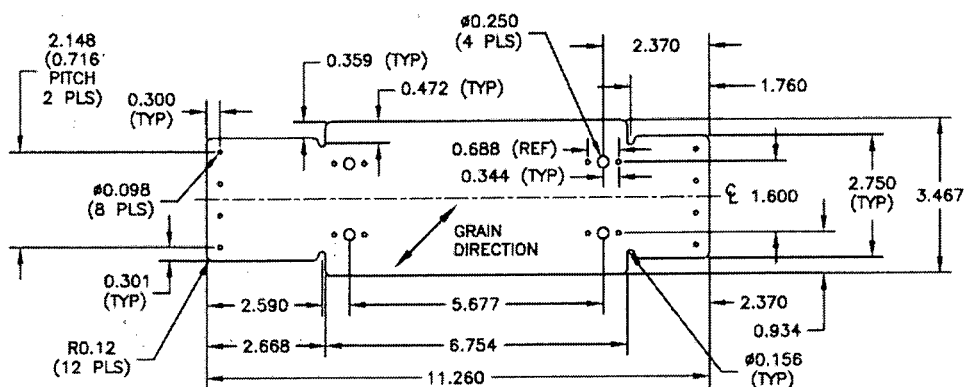
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

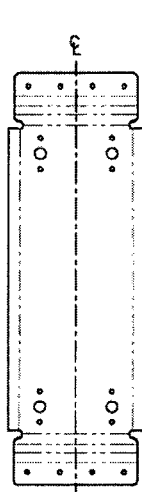


DESIGN JH	DRAWN BY FF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JH	APPROVED JH	DRAWING NO. D3246	REV. A SHEET 1 OF 1
DATE 04.04.21		TITLE MOUNTING BRACKET	SCALE 1:4
A	04.04.21	NEW ISSUE	
AI	04.06.16	CHANGE RIVET; ADDED C'SINK	

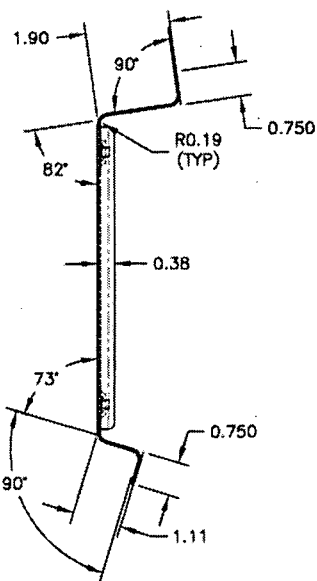
RELEASED  
04.05.07



D3246-1 FLAT PATTERN



D3246-1 BEND DETAIL



D3246-041 ASSEMBLY

NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.050 THICK (REF. DART SPEC. M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DART AEROSPACE LTD		Work Order: 39777
Description: MOUNTING BRACKET		Part Number: D3246-01
Inspection Dwg: D3246-01 (Rev: A)		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .098	+ .004 - .001	.102	X			
Ø .250	+ .006 - .001	.254	X			
.300	+/- .010	.301	X			
.301	+/- .010	.302	X			
2.148	+/- .010	2.145	X			
.716	+/- .010	.715	X			
.472	+/- .010	.472	X			
.359	+/- .010	.359	X			
1.760	+/- .010	1.760	X			
2.370	+/- .010	2.371	X			
1.600	+/- .010	1.601	X			
2.750	+/- .010	2.748	X			
3.467	+/- .010	3.466	X			
.934	+/- .010	.935	X			
2.370	+/- .010	2.373	X			
2.590	+/- .010	2.590	X			
2.668	+/- .010	2.670	X			
5.677	+/- .010	5.678	X			
6.754	+/- .010	6.750	X			
11.260	+/- .010	11.260	X			

Measured by: JB	Audited by: S	Prototype Approval: u/
Date: 8-6-10	Date: 08/06/10	Date: 7

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	